

Order # 3629
Cm2f

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA25A-210
Job Sheet 172851



Part No: SWA25A-210

Job Qty: 6 ea

Part Name: Upper End Swivel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/22/18

Job Tracking No:

Due Date: 3/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA25A-210 REV:6 IPP REV A 18.02.20 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
90	Start up Operation	6 Ea	3/22/18	3/22/18	0.00	0.00	Start Up Machining-3		2/18/03/14
110	Mori Seiki	6 pcs	3/22/18	3/22/18	0.00	0.00	MORI NLX		
120	QC	6 pcs	3/22/18	3/22/18	0.00	0.00	QC2		
122	CNC Vertical Machining	6 pcs	3/23/18	3/23/18	0.00	6.00	MORI NLX 5000		2/18/03/14
124	QC	6 pcs	3/23/18	3/23/18	0.00	0.00	QC2 Machining-3		2/18/03/14
130	QC	6 pcs	3/23/18	3/23/18	0.00	0.00	QC8		2/18/03/14
140	Packaging	6 pcs	3/23/18	3/23/18	0.00	0.00	Packaging3		2/18/03/14
150	QC21-SA	6 Ea	3/23/18	3/23/18	0.00	0.00	QC21		2/18/03/14

Part Op 110 - Cut Blanks AT 7.00" 1-Machine as per DWG. FB902 FOLIO REV: _____ DWG REV: _____ 2-

Descriptions: Deburr ***Machine engrave up arrow***

122 - -Use SWA25A-200 and modify groove as per DWG 1-Machine as per DWG. FB902 FOLIO REV: _____

DWG REV: _____ 2-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
SWA25A-200P	Upper End Swivel	6 pcs (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	SWA25A-200P	6	9	0

Part Specifications

Specifications could not be found.

Plex 3/1/18 2:07 PM Dart.Gagnon.Michelle



Container No: 8051373



Part: SWA25A-210

Job No: 172851

Serial No/Batch: 8051373

Revision: 6

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/14/18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

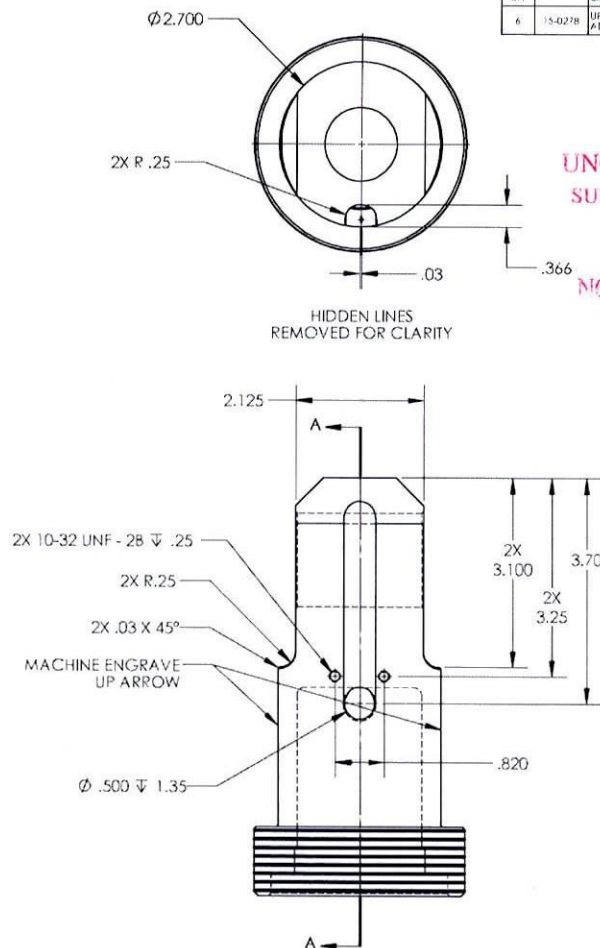
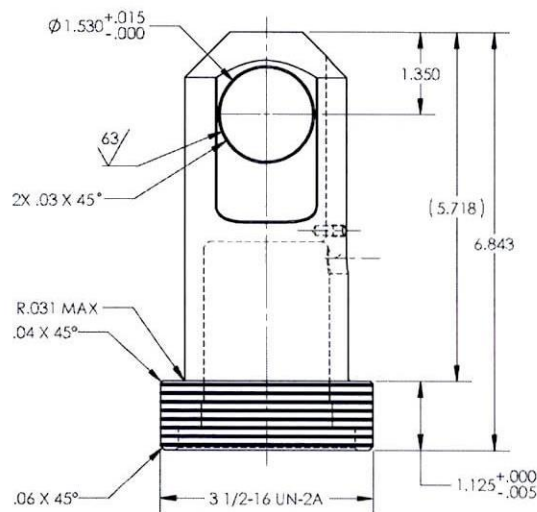
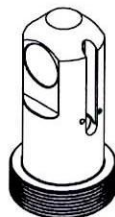
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

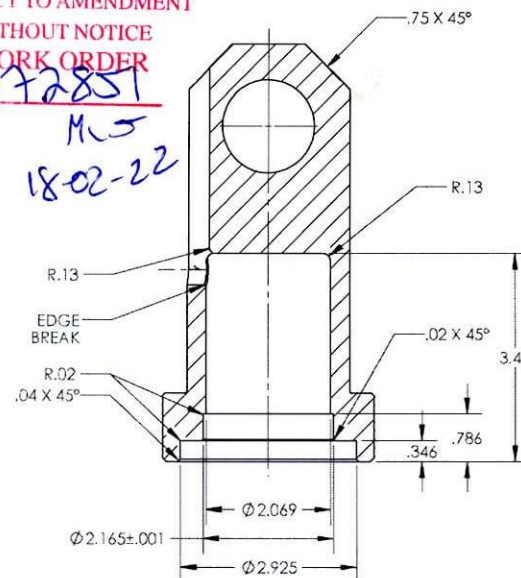
Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 172851

MCS
 18-02-22



SECTION A-A

ASSY QTY	ASSY QTY	B/C	Part #	UNIT QTY	Description	Material	N/O INFORMATION OR SPECIFICATIONS
			SWA25A-210	1	UPPER END SWIVEL	SS 17-4, H1150/H1075	

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5		AS DRAWN BY CANAM	11/12/2012	JAG	
5A		CHD B/O INFO TO BLANK	4/29/2014	JAG	RW
6	15-0278	UPDATED TO NEW DRAFTING STANDARDS. ADDED UP ARROW NOTE. ADDED MATL OPTION H1075. ADDED DIMS FROM SWA10A-200 BLANK DWG.	9/21/2015	DDP	JAG

DART AEROSPACE	
TITLE: UPPER END SWIVEL	
DWG NO. SWA25A-210	REV 6
MATL: SS 17-4, H1150/H1075	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED: <i>D. Wood</i>
.XXX ± .005 FRACTIONS ± 1/8	TEST:
.XX ± .01 ANGLES ± 5°	FINISH:
.X ± .1	SPEC:
1. BREAK ALL SHARP EDGES .015 X 45°	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE: 1:2	DATE: 2/22/2002
SHEET 1 OF 1	

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER :					